



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12890 ✓	27/66
2	Machined By		VTC M/c Shop	Dwg No. - LSD 609
3	Pallet Die No.		13326 (60mm) ✓	(REV09)
4	Die Category	Drg. No.	M Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm ✓	Step length - 31mm ✓
6	Inside Diameter	Drg. No.	548.1 mm ✓	Taper - 8° ✓
7	Width of Pellet Die	Drg. No.	195 mm ✓	Under wt - 2.5mm ✓
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm ✓	4X8mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	[Tapping No. of]
10	Drilling Area Surface Smoothness		ok ✓	Holes ?
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		619mm ✓	
13	Tapping Hole Diameter		M 16 check by M 16 Bolt ✓	Face side step
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	2mm Deep Both Side
15	Tapping Hole Depth		Drill Depth - 31.8mm Tapping Depth - 31.8mm ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok ✓	

### Inspected By (Sign) & Date

Ramanjeet Singh 16/09/24

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 30°

1	Counter Sinking Depth & Finish	ok								Row - 12
2	External Relief Dia	7.0 mm	RD Poles							
3	External Relief Depth		39mm ✓							
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		16	09	24					

### Inspected By (Sign) & Date

Ramanjeet Singh 16/09/24

Reviewed by (Engineer-CNC)

Manager-QA